

Split

Work Order ID 50004A -1

July 2, 2009 3:37:49 PM



Page 1

Item ID: D3011-1

Accept

Revision ID: A

Setup

Stop



Item Name: Rappel

50004

Start Date: 07/06/2009 Start Qty: 10.00



Required Date: 07/15/2009 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
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D3011	Rev A
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100



BAND SAW

Bandsaw

Jespa Bandsaw

Memo

Cut Blanks: 26.57"

110



HAAS CNC VERTICAL MACHINING #1

Memo

Ensure Batch Number programmed matches this W/O

*
Machine as per folio FA129

120



QC2- Inspect parts off machine FA1/FA1B

Memo

0.00

QC

Quality Control

0.00 *28/07/17* *28/07/17* *mnz* *28/07/20*

0.00 *28/07/17* *28/07/17* *mnz* *28/07/20*

4

4

4

Work Order ID 50004

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Item ID: D3011-1

Accept

Revision ID: A

Setup Start

Item Name: Rappel

Stop

Start Date: 07/06/2009 Start Qty: 10.00



Required Date: 07/15/2009 Req'd Qty: 10.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

④.

0.00

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 112148

Memo

START TIME: 1:25
OVEN TEMPERATURE: 300°
FINISH TIME: 1:55

0.00

④.

Work Order ID 50004

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Item ID: D3011-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Rappel

Start Date: 07/06/2009 Start Qty: 10.00

Required Date: 07/15/2009 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

SB

4 0

0.00

0.00

SB

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Last Print

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Page 1

Work Order ID: 50004



Parent Item: D3011-1RevA

Parent Item Name: Rappel

Comments:

Start Date: 07/06/2009

Required Date: 07/15/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6202RevA 		Manufactured	No			110	f	36.1000	10.0000			

I-Beam Extrusion

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT	36.1	
14742	6.1	
37669	30	

B 500 40

11.000
49.11
On Hold 7/20

DART AEROSPACE LTD		Work Order:	50009
Description: Rappel Slide Bar		Part Number:	D3011-1
Inspection Dwg: D3011-1	Rev: A		Page 1 of 1

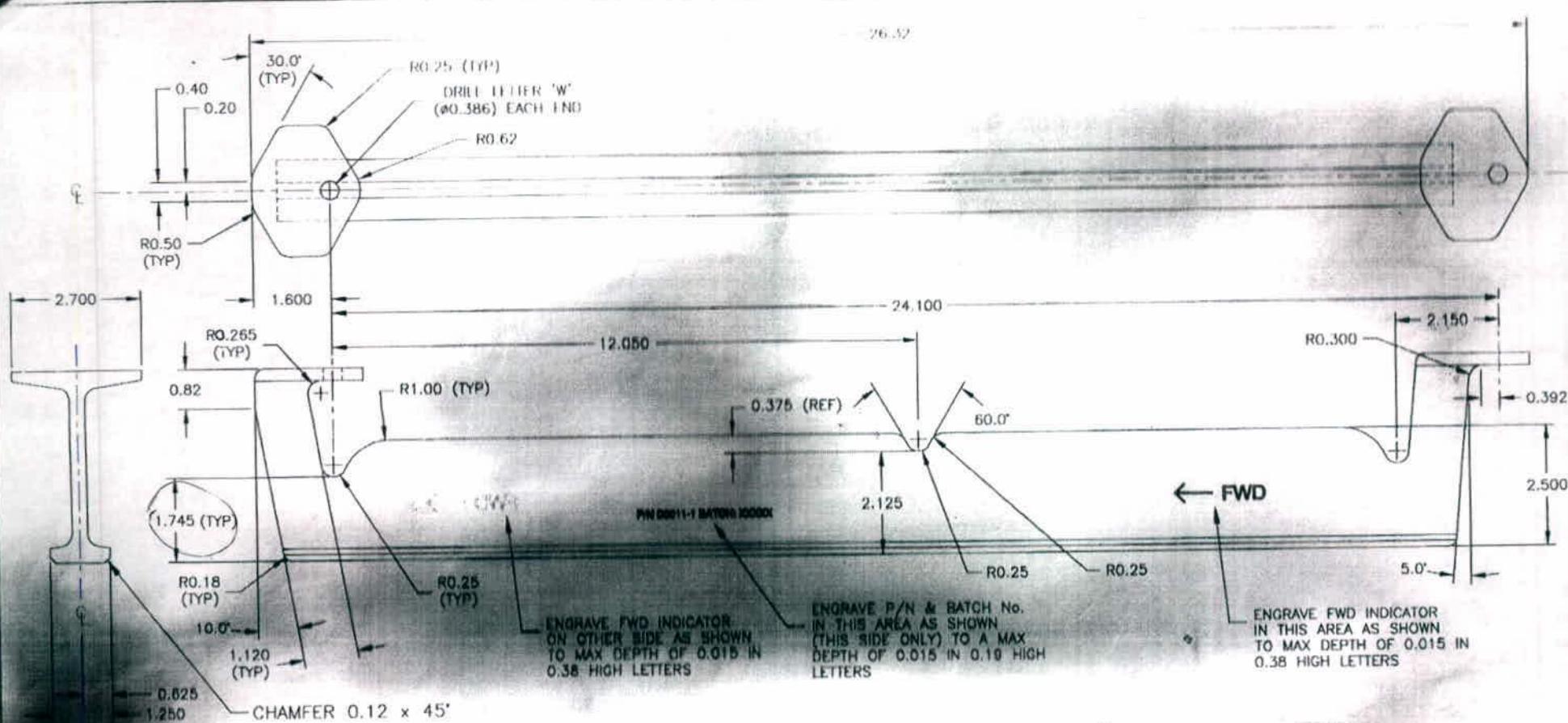
FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.700	+/-0.010	2.700	—			
1.250	+/-0.010	1.254	/			
0.625	+/-0.010	0.625	✓			
0.120 x 45°	+/-0.010 x +/-0.5°	0.120 x 45°	✓			
Ø0.386	+0.005/-0.001	Ø.388	✓			
1.600	+/-0.010	1.600	—			
26.32	+/-0.030	26.32	—			
R0.50	+/-0.030	R.500	—			
30°	+/-0.5°	30°	✓			
0.275	+/-0.010					
2.500	+/-0.010	2.494	—			
5°	+/-0.5°	5°	✓			
24.100	+/-0.010	24.100	✓			
1.125	+/-0.010					
R0.25	+/-0.030	R.250	—			
0.375	+/-0.010	.376	—			
1.120	+/-0.010	1.123	—			
1.745	+/-0.010	1.744	—			
0.82	+/-0.030	.810	—			
10°	+/-0.5°	10°	✓			

Measured by:	<i>DK</i>	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	09/07/19	Date:	09/07/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.04	New Issue	KJ/DD <i>J</i>	<i>M</i>



TURE FROM D6202-027 EXTRUSION
ALL SHARP EDGES 0.010-0.020
AND ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD.

A		01.03.29	NEW ISSUE
DESIGN	DRAWN BY	OP	DART AEROSPACE LTD. HAMILTON, ONTARIO, CANADA
CHECKED	APPROVED	A	DRAWING NO. D3011
DATE		01.03.29	SCALE 1:2 TITLE RAPPEL SLIDE BAR